

skip Oct. 29

Work Order ID 63068

Tuesday, October 19, 2010 3:33:36 PM



Page 1

Item ID: D4073-3

Accept



Setup Start



Revision ID:

Item Name: Door Hinge Backing Plate

Stop



Start Date: 10/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/19 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4073 | A |

100



Waterjet

FLOW CNC Waterjet

6661 .663

Memo

1-Cut as per Dwg
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

0.00

10-10-21

3

10-10-21

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

10-10-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 63068

Tuesday, October 19, 2010 3:33:36 PM



Page 2

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Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



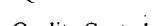
QC8- Inspect parts - second check

0.00

3

10/10/21

QC



Memo

JH-03

0.00

Quality Control

130

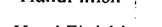


Chemical Conversion Coat per QSI005 4.1

0.00

JH 10/10/22

HandFinish



Memo

0.00

X3 4

140

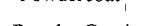


White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

JH 10/10/25.

Powdercoat



Powder Coating

Memo

0.00

3

POWDER COAT:
Start Time: 3:40:30
Oven Temperature: 300
Finish Time: 4:10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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NOTE: Date & initial all entries

Work Order ID 63068

Tuesday, October 19, 2010 3:33:36 PM



Page 3

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Revision ID:

Item Name: Door Hinge Backing Plate

Start Date: 10/19/2010 Start Qty: 2.00

Accept



Setup Start



Required Date: 10/26/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

=> 30

10/10/28

3

0

QC

Quality Control

Memo

0.00

160



Identify as per dwg & Stock Location: 121

0.00

10/10/29

3

Packaging

Packaging

Memo

0.00

D. DAWAL

10/11/08 (3)

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/10/29

C21011101

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, October 19, 2010 3:33:40 PM

Work Order ID: 63068



Parent Item: D4073-3



Parent Item Name: Door Hinge Backing Plate

Start Date: 10/19/2010

Required Date: 10/26/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.063 6061-T6 .063 Sheet | | Purchased | | No | | 100 | sf | 52.4340 | 0.02777 | 0.058463 | | 10-16-10 | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT21 | 52.434 | |
| 113608 | 52.434 | |

10609

(3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

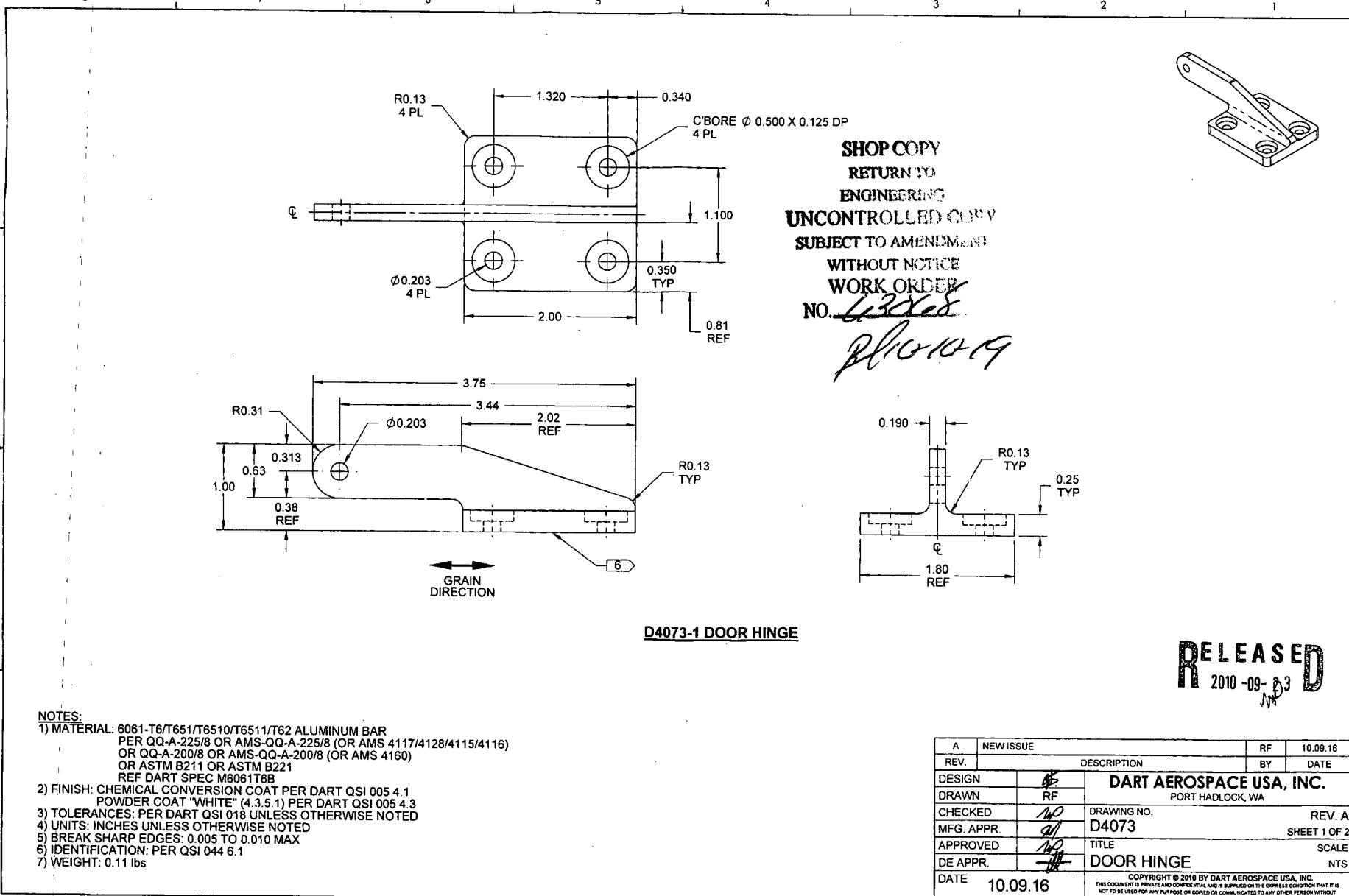
| | | |
|---------------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 63068 |
| Description: DOOR HINGE BACKING PLATE | Part Number: | D4673-3 |
| Inspection Dwg: D4673 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | B | Audited by: | C | Prototype Approval: | N/A |
| Date: | 10-10-21 | Date: | 10-10-21 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



| A | NEW ISSUE | RF | 10.09.16 |
|------------|-----------|---|--------------|
| REV. | BY | DATE | |
| DESIGN | <i>GP</i> | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | <i>AD</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>GP</i> | D4073 | SHEET 1 OF 2 |
| APPROVED | <i>AD</i> | TITLE | SCALE |
| DE APPR. | <i>GP</i> | DOOR HINGE | NTS |
| DATE | 10.09.16 | COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION OWNED BY DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

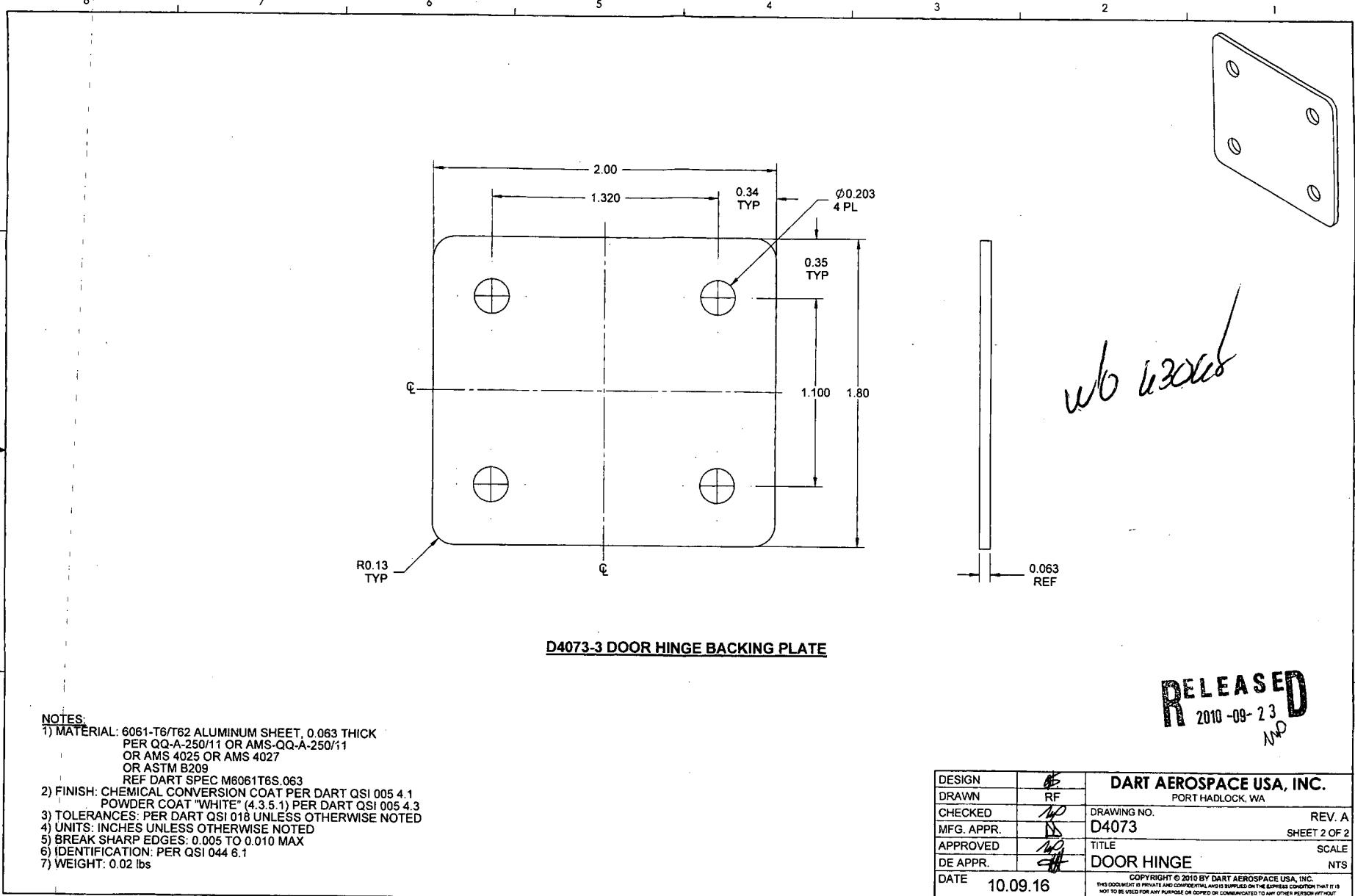
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------|-----------|--------------------------|--|
| DESIGN | <i>RF</i> | DART AEROSPACE USA, INC. | |
| DRAWN | <i>RF</i> | PORT HADLOCK, WA | |
| CHECKED | <i>RF</i> | DRAWING NO. | |
| MFG. APPR. | <i>RF</i> | D4073 | |
| APPROVED | <i>RF</i> | REV. A | |
| DE APPR. | <i>RF</i> | SHEET 2 OF 2 | |
| DATE | 10.09.16 | TITLE | |
| | | SCALE | |
| | | DOOR HINGE | |
| | | NTS | |

RELEASED
2010-09-23
WB 130X6

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Receiving Report

Date: 10/01/11
 Supplier: MA6 NO
 Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Batch No: M1/3608
 Dart P/O: 11060

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection: Yes No N/A
 Work Order: 10/01/11 N/A N/A

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|-------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| | | | | | | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) RL Level 12

Production/Admin: 10/01/11
 Date
 Received/Costing Initial RL

Location

Purchase Order Receipt Listing

January 11, 2010 8:56:50 AM

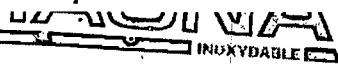
Page 1 of 1

All amounts are calculated in domestic currency.

Vendors PO ID PO11060 Receipt Dates from 1/11/2010 to 1/11/2010 All Line Item Types
 Item ID/GL/WOs All Rec. Employees All Currencies
 Grouped by Vendor ID

| Purchase Order ID/ Line Nbr/ Type | Line Nbr/ Insp Req | Project ID | Reference/ Description/ Cert Std | PO U/M / Stock U/M | Required Date Required Qty | Recv Date/ Recv Emp | Recv Qty (PO U/M) | Cost Per Unit/ Recv Value | Inspected Qty/ Rejected Qty (PO U/M) | MRB Qty/ MRB Reject Qty | Book Amt |
|---|-----------------------------|------------|--|-----------------------|-------------------------------|---------------------------|-------------------------|------------------------------|--|-------------------------------|------------|
| 11060 | 2 | VC-MAG002 | Magna Stainless | | | | | | | | |
| | | | M6061T6B00750X00 f | | | | | | | | |
| | | | .125 | | | | | | | | |
| | | | 6061-T6 Bar .750 x f | | 1/11/2010 | 1/11/2010 | 80.0000 | \$0.25 | 0.0000 | 0 | \$20.00 |
| | | | .125 | | | | | | | | |
| | | | 113608 | | | | | | | | |
| | 3 | | M6061T6B2.000X01 f | | | | | | | | |
| | | | 250 | | | | | | | | |
| | | | 6061-T6 Bar 2.00 x f | | 1/11/2010 | 1/11/2010 | 40.0000 | \$11.08 | 0.0000 | 0 | \$443.20 |
| | | | 1.25 | | | | | | | | |
| | | | 113608 | | | | | | | | |
| | 4 | | M6061T6S.125 sf | | | | | | | | |
| | | | 6061-T6 .125 Sheet sf | | 1/11/2010 | 1/11/2010 | 96.0000 | \$5.94 | 0.0000 | 0 | \$570.00 |
| | | | 113608 | | | | | | | | |
| | 5 | | M6061T6S.063 sf | | | | | | | | |
| | | | 6061-T6 .063 Sheet sf | | 1/11/2010 | 1/11/2010 | 288.0000 | \$4.53 | 0.0000 | 0 | \$1,304.99 |
| | | | 113608 | | | | | | | | |

| | |
|--------------------------------|------------|
| Total Received Quantity: | 504.0000 |
| Total Qty to Inspect (PO U/M): | 0.0000 |
| Total Reject Quantity: | 0.0000 |
| Total Receipt Value: | \$2,338.19 |
| Total Balance Due Quantity: | 0.0000 |



Magna Stainless

Magna Stainless
5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

D TO
T AEROSPACE LTD
0 ABERDEEN STREET

KESBURY
1K7
tact: CHANTAL

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY
K6A 1K7
Ship Terms: PREPAID

A standard linear barcode is located in the top right corner of the page.

PACKING LIST

Page 1 of 1

I021555

SPECIAL INSTRUCTIONS

| | | | | | | |
|----------------|--------------|--------------|----------------|----------------|---------------|--------------|
| Currency | | Sales Person | Customer Phone | Customer Fax | Customer PO | |
| JADIAN DOLLARS | | ERYCK BLAIS | (613) 632-5200 | (613) 632-1053 | PO11060 | |
| les Order | Terms | | Ship Via | Date Ordered | Date Required | Date Shipped |
| 3590 | NET 30 DAYS | | NIR:R-557065-1 | 01/07/10 | 01/11/10 | 01/11/10 |
| dered | Back Ordered | Unit | Description | | | |

✓ 10/5/11

| Approx | Weight |
|--------|--------|
|--------|--------|

561 LB



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO11060

Purchase Order Date 1/07/10
PO Print Date 1/07/10

Page Number 2 of 2

Order From : VC-MAG002
MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone 800 363 6646
Vendor Fax 514 339 1105
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

ALUMINUM SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-
250/11 OR AMS 4025
AMS 4027 OR ASTM B209

5 M6061T6S.063 6061-T6 .063 Sheet
1/11/10 256.00 Yours ppd \$4.5312 \$1,159.99
Yes sf *AC 288* *10/01/11*

6 M2024T3S.080 2024-T3 .080 sheet
1/15/10 196.00 Yours ppd \$10.9375 \$2,143.75
Yes sf

Special Inst: MATERIAL SAME AS ABOVE
Special Inst: MATERIAL: 2024-T3 ALUMINUM
SHEET
AS PER QQ-A-250/4 OR AMS-QQ-
AA-250/4 OR
AMS 4037 OR ASTM B209

7 M7075T6B1.000X1.000 7075 T6 BAR 1.00 x1.00
1/15/10 12.00 Yours ppd \$16.2500 \$195.00
Yes f

Special Inst: MATERIAL: 7075-T6/T651/T6511/T62
ALUMINUM BAR PER AMS-QQ-A-
225/9 OR AMS 4122/4123/4186/4187
OR
PER AMS-QQ-A-200/11

M304TS0.750W.049 304 SQ Tube
.75x.75x.049W
1/15/10 100.00 Yours ppd \$3.2500 \$325.00
Yes f

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Special Inst: MATERIAL: 304 SEAMLESS
SQUARE TUBING NO MILL FINISH

PO Total: \$4,831.66

CL
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Novelis Inc.
1 LAPPAN'S LANE
P.O. BOX 2000
KINGSTON, ONTARIO, CANADA K7L4Z5

CERTIFICATION OF PROPERTIES AND
CHEMICAL ANALYSIS

SOLD TO:
MANDEL METALS INC
11400 ADDISON STREET

SHIP TO:
MANDEL METALS INC
11400 ADDISON STREET

FRANKLIN PARK IL
60131

FRANKLIN PARK IL
60131

PRINT DATE:
2009/04/17

CUST PO: 02-11632

LOAD: HZ84

PACK: 52644221

CUST PART #:

COIL:

ALLOY: 6061

TEMPER: T6

GAUGE:

MECHANICAL SPECIFICATIONS:

AMS-QQ-A-250/11-97 ASTM B209-02 AMS4027M

GAUGE LENGTH = 2.00 in

K05406A
0.0630 in

SALES ORDER: 66515340-0010

NET WT: 9237 lbs

WIDTH: 48.000 in

I certify that the materials detailed herein have been tested and that
documentary evidence of the test or release certificate is on file.

Per


Process Leader

| Location: FRONT END | UOM | TEMPER | TEST DATE |
|---------------------|-----|--------|-------------|
| UTS | ksi | T6 | 17-APR-2009 |
| YTS | ksi | T6 | 17-APR-2009 |
| Elongation | % | T6 | 17-APR-2009 |
| Tensile Thickness | in | T6 | 17-APR-2009 |

| Location: BACK END | UOM | TEMPER | TEST DATE |
|--------------------|-----|--------|-------------|
| UTS | ksi | T6 | 17-APR-2009 |
| YTS | ksi | T6 | 17-APR-2009 |
| Elongation | % | T6 | 17-APR-2009 |
| Tensile Thickness | in | T6 | 17-APR-2009 |

| Chemistry | LAYER: 01 | ***** | | | | | | |
|--------------|---------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| Al 97.6900 | Si 0.5500 | Fe 0.4600 | Cu 0.2200 | Mn 0.0100 | Mg 0.8800 | Cr 0.1700 | Ni 0.0000 | Zn 0.0100 |
| Ti 0.0100 | Be 0.0000 | Pb 0.0000 | | | | | | |
| EACH: 0.0000 | TOTAL: 0.0000 | | | | | | | |

04/17/09
btech